

84386

Page 1

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/05/2012 **Start Qty:** 40.00

40

Cust Item ID:

Required Date: 25/05/2012 **Req'd Qty:** 40.00

40

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 12/05/11

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	BAND SAW	0.00	F.K.	12/06/11		40	Ø		
D2873	Memo	0.00							
Cut blanks:	1.000" x 0.375" x 3.700" long								
110	HAAS CNC VERTICAL MACHINING #1	0.00	F.k	12/06/11		40	#		
Machine as per Folio FA		0.00							
Dwg Rev A	Folio Rev A								
120	QC2- Inspect parts off machine FAI/FAIB	0.00	F.K -	12/06/11		40	A		
Quality Control		0.00	SF	12-6-12					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 84386***84386***

Page 3

May-11-12 8:15:58 AM

Item ID: D2873-043

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Nut Plate Assembly

Start Date: 11/05/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 25/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.00							
Hand Finishing									
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	1-Assemble as per Dwg D2873 2-Identify as D2873-043								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84386

84386

Page 4

May-11-12 8:15:58 AM

Item ID: D2873-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Nut Plate Assembly
 Start Date: 11/05/2012 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 25/05/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		<i>Sczlocu4</i>		<i>counts</i> <i>(40)</i>			
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200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG52</u> Memo	0.00 0.00				<i>AG</i>	<i>12 - 6 - 16</i>	<i>(40)</i>	
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210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					<i>12/6/18</i>	<i>MF</i> <i>12-06-18</i>	
--	---	------------------	--	--	--	--	----------------	------------------------------	--

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

May-11-12 8:16:01 AM

Page 1

Work Order ID: 84386

84386

Parent Item: D2873-043

D2873-043

Parent Item Name: Nut Plate Assembly

Start Date: 11/05/2012

Required Date: 25/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5		Purchased	No			100	Each	26.0000	3	120			
MS21075L 5										**			
Nut Plate													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST304		26							
				121444		26							
M6061T6B0.375X01.00		Purchased	No			180	f	13.3480	0.3083	12.98105			
0										**			
M6061T6B0 375X01 000													
6061T6 BAR .375 x 1.00													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT001		2.292							
				118641		2.292							
				MAT002		11.056							
				120603		0.76							
				120866		0.76							
				121192		9.536							
MS20426AD4-6		Purchased	No		121836	180	Each	2,110.000	6	240			
MS20426AD4-6										**			
Rivet													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST317		2110							
				110139		187							
				118510		253							
				119436		670							
				121708		1000							

12/06/14
26
1121827
942
12.982
F.K. 12/06/11
240
12/06/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Radius Block		Part Number:	D2873-3
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

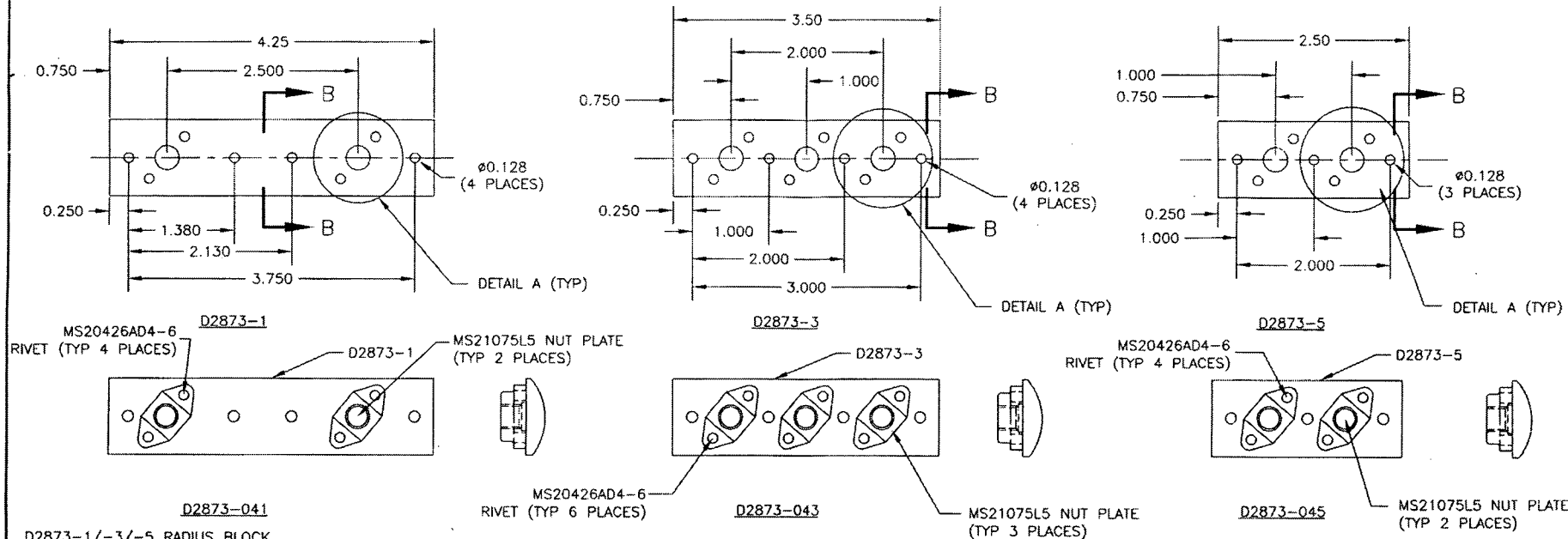
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.50	+/-0.030	3.501	✓			
2.000	+/-0.010	2.000				
0.750	+/-0.010	.750				
1.000	+/-0.010	1.006				
0.250	+/-0.010	.250				
1.000	+/-0.010	1.000				
2.000	+/-0.010	2.000				
3.000	+/-0.010	3.000				
Ø0.128	+0.005/-0.001	.128				
0.359	+/-0.010	.359				
Ø0.316	+0.006/-0.001	.317				
1.000	+/-0.010	1.000				
0.250	+/-0.010	.249				
0.061	+/-0.010	.061				
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.230 x .123				

Measured by: F.K. / RF	Audited by: B.	Prototype Approval:	N/A
Date: 12/06/11	Date: 12/06/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-043	KJ/JLM	<i>[Signature]</i>



D2873-1/-3/-5 RADIUS BLOCK

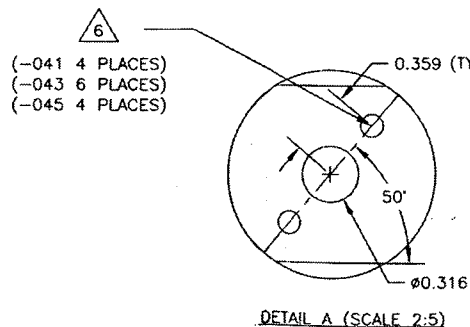
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE

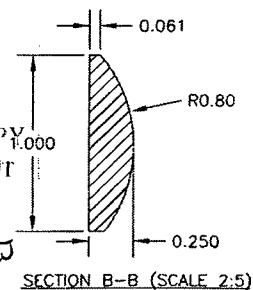


DETAIL A (SCALE 2:5)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 84386 MW

12/05/11



SECTION B-B (SCALE 2:5)

RELEASED
05-07-26

A	05.07.26	NEW ISSUE
DESIGN PH	DRAWN BY PH	DART DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA
CHECKED DS	APPROVED DS	DRAWING NO. D2873
DATE 05.07.26	TITLE RADIUS BLOCK	REV. A SHEET 1 OF 1 SCALE 4:5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No⁷ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries